Work Order ID 88845 *88845* Tuesday, August 07, 2012 3:26:23 PM Item ID: D350-764-011 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Shoulder Harness **Start Date:** 8/7/2012 Start Qty: 4.00 *4* **Cust Item ID: Required Date: 8/13/2012** Req'd Qty: 4.00 **Customer:** Reference: Run Date: 2-09-07 Tooling: Process Plan: Approvais: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Qty Qty Number Stamp Code Draw Nbr Revision Nbr IIN-D350-764 · Rev B - U/R 100 0.00 DOCUMENT CONTROL *100* MUJ 12/08/10 DC 0.00 Memo Document Control Photocopy bluefile & type labels per PPP D350-764-011 110 Pick Kit 0.00 Packaging *110* Packaging 0.00 Memo Packaging 120 QC4-100% Inspect kits for completeness *120* QC 0.00 Memo

Quality Control

B

												DQA:	Da	ate:	•
NCR:	Yes /	No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		•		,	
											_	QA Closed:	Da	ite:	
Work Orde	er:					DISPOSITION				AGAINST DE	EΡ	ARTMENT/	PROCESS		
Part I	No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root			· .		Descri	otion of work order update		Initial	Ac	tion	Τ	Sign &			
Cause	ַ ב	ate	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							٠	,							
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Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde Tuesday, August				*888	45*					Page 2
Item ID: Revision ID: Item Name:	D350-764-0 Shoulder Harr			Accept	*N90004	010	N *	Setup S	tart Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	8/7/2012 8/13/2012	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:					14(7)
Approvals:		nn:	Date:		Date:				tart Stop	*NR1* *NR2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours 0.00	Tool ID Too	l# Plan Code	Accep	ot Rejec Qty	N	eject Insp. umber Stamp
130 Packaging Packaging		Packaging Memo Identify and Location: PPP Rev:	pack for shipping as per	0.00 SN 7	2		4)		!	2/8/1024
140		QC21- Final Inspection	- Work Order Release	0.00						0 (- G) r
140 QC Quality Control		Memo		0.00				<u> M</u>	J :	2008/ t

											DQA:	Date:	•
NCR:	Yes	/ No				WORK ORDER NON-C	01	NFORM	MANCE / UP	DATE	04 Classid		***************************************
											QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	- No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	e e					·	ż	•					
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Landi		Bending Centre No Cracks Crushed/C Cuffs Heat Trea nspection	Crimped. t n Strip in		O/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misread	on Incomplete ions Incomplete/I nance led	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Tuesday, August 07, 2012 3:26:20 PM

Work Order ID:

88845

Parent Item:

D350-764-011

Parent Item Name:

Shoulder Harness

Start Date: 8/7/2012

Required Date: 8/13/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV:A New issue 07-10-11 DD verified by EC IPP Rev:B ECN 1050 rev.B as per dwg 08-01-10 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date S Issued	Status
ALS4-1032-130 Insert		Purchased	No		2.	110	Each	2,229.0000	116	64	-		S
(Location		Loc Qty	<u>L</u> c	oc Code					V .
				ST280		205							
					9084	116							
					0671	89				,			
				ST281		1884							
					0807	36							
					0837 2474	8 1840			/22	1474			
1				ST282	5474	140			/ ===				
					1269	140						_	, ,
AN3-3A Bolt		Purchased	No	.2	0,	110	Each	331.0000	32	128		Ø	
•				Location		Loc Oty	Lo	oc Code					
				ST350		331			 _			•	
					0423	231			/20	923		_	
1000				122	2416	100				·			
AN3-6A Bolt		Purchased	No			110	Each	199.0000	16	64		1/2/2/	fs (
				Location		Loc Qty	Lo	oc Code					
				ST351		199							
					7441	34			-/-	<u>, </u>	100	•	
)644	15			120	12/66			
					1060 1166	50 100				121/1	(C) 3	6	

NCR:	Yes	/ No				WORK ORDER NON-O	O	NFORM	MANCE / UP	DATE					
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Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT,	PROCESS		
Part f	No.					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		4	Water Je d. Eng. Coor re/Packaging Supplie		Engineering Quality Other
Root						ption of work order update		Initial	-	tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificati	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														-	
							AUL	T CATE	GORY						· · · · · · · · · · · · · · · · · · ·
Landi		Gear Bending Centre No Cracks Crushed/C Cuffs Heat Trea	Crimped.		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		1	on Incomplete ions Incomplete/ nance led	Unclear		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
]		Rinnles in	Rend			Drill Holes		Offset							

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Tuesday, August 07, 2012 3:26:20 PM

Work Order ID: 88845 Parent Item: D350-764-011 **Required Date: 8/13/2012** Start Date: 8/7/2012 Parent Item Name: **Shoulder Harness** Required Qty: 4.00 Start Oty: 4.00 Purchased No 110 Each 106.0000 16 Location Loc Oty Loc Code ST355 50 50 122407 ST356 56 117619 6 21666 121666 50 NAS1149D0363J Purchased No 110 0.0000 192 Each NAS1149D0963J No 110 0.0000 Purchased Each 16 No 110 Each 76.0000 Purchased 16 Location Loc Qty Loc Code ST344 76 120770 12/060 121060 75 Purchased No 110 Each 292.0000 Loc Code Location Loc Qty ST331 292 113973 2 117849 61 119017 229 CR3212-4=2 No 110 Each 219.0000 Purchased Location Loc Qty Loc Code ST331 219 110806 6 112794 13 121090 200

			DQA:	Date:	· ,•
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	W		
			OA C!!	D-4	

										QA Closed:	Dat	e:
Work Ord	er:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part I	-					Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Initial	A	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator			-									¢.
Material	Ш				1							
Setup	Ш		!		-							
Other	Ш											
Process	Ш				:		1					·
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Training	Ш						į					
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	-	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardv			Over/Under	ŀ	Temperature/Cure
	-	Cracks			_	Broken/Damaged		ction Incomplete	<u> </u>	Part Incorre)	Weld
	_	Crushed/0	Crimped.		_	Burrs	_	ctions Incomplete	/Unclear	Part Lost/M		Wrong Stock Pulled
	$\boldsymbol{\vdash}$	Cuffs			<u> </u>	Contamination	\vdash	tenance		Part Moved		
		Heat Trea			_	Countersink	Mislal		_	Positioned \	· · ·	
	-	Inspectior -	•	Tube		Cut Too Short	Misre			Power Loss,	/Surge	Other
		Ripples in			ļ	Drill Holes	Offset					
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	-	Turning S	•			Finish	\vdash	f Sequence				
I	1 1	Wave/Tw	ist in Tuk	ne .	j	Folio	I lOutsid	de Dimensions				

Tuesday, August 07, 2012 3:26:21 PM

Work Order ID: 88845 Parent Item: D350-764-011 **Start Date: 8/7/2012** Required Date: 8/13/2012 Parent Item Name: Shoulder Harness Start Qty: 4.00 Required Qty: 4,00 CR3212451021 No 110 192.0000 Purchased Each 16 Location Loc Qty Loc Code ST331 192 112082 m/21048 191 121048 No Purchased 110 Each 126.0000 Location Loc Qty Loc Code ST331 126 120833 120833 26 121048 100 D2854 110 No Manufactured 140.9980 2.666 10.664 3/4" Velcro Strip (4X) 8.00° per dwg D2854-1/-3-080 Location Loc Qty Loc Code ST415 140.9980032 69425 4.71474 69562 0.376 83561 0.00726316 86156 15.9 86440 120 Manufactured No 110 Each 64.0000 Doubler 18887657 Location Loc Oty Loc Code ST244A 50 65269

50

14

14

80921

80380

ST245A

80380 60/

			4								DQA:	Date	::
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE			-
											QA Closed:	Date	:
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part f	- _ No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						-							
							AUL	LT CATE	GORY	 .			
Landi		ear Bending Centre No Cracks Crushed/G Cuffs Heat Trea nspection	Crimped. et		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		⊣ `	on incomplete ions incomplete/i nance led	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
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Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Tuesday, August 07, 2012 3:26:21 PM

Work Order ID:

88845

Parent Item:

D350-764-011

Parent Item Name:

Shoulder Harness

Start Date: 8/7/2012

Required Date: 8/13/2012

Start Qty: 4.00

Required Qty: 4.00

Shoulder Harness

D3636-041

Manufactured No 110

Loc Qty

Loc Qty

Each

16.0000

Loc Code

16

D3637-041 Bracket Assembly

Manufactured

82272 ST266

Location

Location

ST235A

Location

ST245A

Location

ST244

ST

No

81368

110

110

Loc Qty

18

6

12

20

20

110 Each

16.0000

82272

Manufactured

82303 ST245A

81487

81488

82391

10 10

Each

Each

Loc Code

18.0000

20.0000

Loc Code

Manufactured

Manufactured

No

No

82738 110

Loc Qty

Each

23.0000

Loc Code

Location Loc Qty Loc Code ST244 23 76273 80422

81490

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NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	JANCE / UPD	DATE		· · · · · ·	
											QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	l	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descri	otion of work order update	1	Initial	Acti	on	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						·							
l and:							AUL	T CATE	JORY				
Landi		Bending Centre No Cracks Crushed/o Cuffs Heat Trea Inspection	Crimped. it n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreac	on Incomplete ions Incomplete/U nance Ied	Inclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
i	1 1	Ripples in	pena		I	Drill Holes	1	Offset					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Tuesday, August 07, 2012 3:26:21 PM

											
Work Order ID:	88845										
Parent Item:	D350-764-011						Start	Date: 8/7/2012	Required	l Date: 8/13/2012	2
Parent Item Name:	Shoulder Harness						Star	t Qty: 4.00	Require	d Qty: 4.00	· 00
D3639-2-		Manufactured	No	·	110	Each	12.0000	لسا	4		
Doubler				Location	Loc Qty		Loc Code				(
l.				ST244	12						
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				84388	10			842	358240		in the
D3639-3° Doubler		Manufactured	No		110	Each	6.0000		4	-5	
				Location	Loc Qty		Loc Code				
				ST244	6				_		
1				77124 80424	5			7712	4		\mathcal{D}^{σ}
				80424	1				<u></u>		-11-
D3639-4 Doubler		Manufactured	No		110	Each	6.0000		4 \	A	_\$\} <u>`</u>
(<u>Location</u>	Loc Qty		Loc Code				1
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		_		80425	1			<u></u>			
D3640-1 Belt Guide		Manufactured	No		110	Each	3.0000	$\begin{bmatrix} 2 \\ \end{bmatrix}$ \mathbf{S}_{L}	11 15 X	9	TO VI
				<u>Location</u>	Loc Qty		Loc Code		11 6/6		
A				ST244	3						_
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D3640-3		Manufactured	No		110	Each	0.0000	[2]	-8 		$\mathcal{T}_{V_{i}}$
Belt Guide									NG/14		<u> </u>
D3641-1 Cover		Manufactured	No		110	Each	16.0000		8 -	L 12,	14/5
1				Location	Loc Qty		Loc Code			•	' 9/
				ST260	16						
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				81543	12			8/6	45		

											DQA:	Date	•
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPE	DATE	QA Closed:	Date	·
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	,	
Part f	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root		,	-		Descri	ption of work order update	١	nitial	Acti	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								,					
						F	AUL	T CATE	GORY				
Landi	ng (Gear				General							
,		Bending Centre No Cracks Crushed/O Cuffs		ntric to	o/s	Bend BOM/Route Broken/Damaged Burrs Contamination		i	on Incomplete ions Incomplete/U	Inclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	ct _	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Ш	Heat Trea	t			Countersink		Mislabe	led		Positioned V	_	
	Ш	Inspection	n Strip in	Tube		Cut Too Short		Misread	l	L	Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Tuesday, August 07, 2012 3:26:22 PM

Tuesday, Mugust	07, 2012 3.20.22 1 W	1									
Work Order ID:	88845										
Parent Item:	D350-764-011						Start	Date: 8/7/2012	Requi	ired Date: 8/13/2	.012
Parent Item Name	e: Shoulder Harness						Star	t Qty: 4.00	Requ	iired Qty: 4.00	-
D3641-3 Cover		Manufactured	No		110	Each	19.0000	0	4 —		
Scover				<u>Location</u>	Loc Qty		Loc Code	400			7
•	•			ST260	19						\
				80417	2				_		•
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D3641-4 Sey Cover		Manufactured	No		110	Each	19.0000	1	4 -		7
-41				Location	Loc Qty		Loc Code	6-3-3-3-3-3-3-3-3-3-3-3-3-3-3-3-3-3-3-3			1/2
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D3642-0 Doubler		Manufactured	No		110	Each	13.0000	2	8 ~		
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				81489	10			80'4	£864		
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				Location	Loc Qty		Loc Code			- //	, ·
				ST244A	8						
				J. 2 1 1/1	8						

80410

											DQA:	Date:			
NCR:	Yes	/ No				WORK ORDER NON-C	10	VFORM	MANCE / UPD	ATE					
											QA Closed:	Date:			
Work Ord	er:					DISPOSITION	AGAINST DEPARTMENT/PROCESS								
Part I	۷o.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root					Descri	ption of work order update	ı	nitial	Acti	on	Sign &				
Cause		Date	Step	Qty	, (or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector		
Doc/Data															
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Training															
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		,			-	F/	AUL	T CATE	GORY						
Landi	ng G	ear				General		_			_		_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced		
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld		
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/M	issing	Wrong Stock Pulled		
		Cuffs				Contamination		Mainte	nance		Part Moved		•		
		Heat Trea	t			Countersink		Mislabe	led		Positioned \	Vrong	•		
		Inspection	n Strip in	Tube		Cut Too Short		Misreac	i		Power Loss,	_	Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Tuesday, August 07, 2012 3:26:22 PM

Work Order ID:	88845									
Parent Item:	D350-764-011						Start	Date: 8/7/2012	Required	Date: 8/13/2012
Parent Item Name	e: Shoulder Harness						Star	t Qty: 4.00	Required	l Qty: 4.00
DE644-0 Shim		Manufactured	No		110	Each	14.0000	2	8	A S
C				Location	Loc Oty		Loc Code			
				ST244A	14				1.	
_				83768	4			837	68148	
				87259	10			87.	25×17×0	1
D3657:17		Manufactured	No		110	Each	10.0000		4\' /	
				Location	Loc Qty		Loc Code			
				ST076	10				_	
				80367	10			803	6 7	
MS20426AD3-3 Rivet		Purchased	No		110	Each	2,571.0000	32	128	
				Location	Loc Qty		Loc Code			
				ST316	2571					
				119109	489			1191	109 (67 111 21	
				121011	1665			1210	<u>√</u> 2,	er.
				19099	417					
M\$20426AD4-4 -4Rivet		Purchased	No		110	Each	3,012.0000	106	424	(1) SN
(Location	Loc Qty		Loc Code			V
				GA	2864					1
				121090	2864			Mla	168 53×	
A				ST317	148			-		
				121068	148			1210	168 53×	
M\$20426AD4-6 Rivet		Purchased	No		110	Each	1,367.0000	28	112	(12/1/8
				<u>Location</u>	Loc Oty		Loc Code			10
				ST317	1367					7.
				110139	- 187					_
				118510	13					
				119436	197			1196	13b	

970

121708

									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	CONFOR	MANCE / UP	DATE	QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	4 1	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		,
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data			·					*			
Equip/Tooling											
Operator			Ì								٠
Material											
Setup											
Other											
Process							·				
Supplier											
Training											
Unapproved .											

ndın	g Gear	General		
	Bending	Bend	Grain	Ovalized Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect Weld
	Crushed/Crimped.	Burrs *	Instructions Incomplete/Unclear	Part Lost/Missing Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved
	Heat Treat	Countersink	Mislabeled	Positioned Wrong
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge Other
	Ripples in Bend	Drill Holes	Offset	
	Torque Waves in Extrusion	Drawing	Out of Calibration	
Γ	Turning Sequence	Finish	Out of Sequence	

Outside Dimensions

FAULT CATEGORY

Wave/Twist in Tube

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Tuesday, August 07, 2012 3:26:22 PM

Work Order ID: Parent Item: Parent Item Name:	88845 D350-764-011 Shoulder Harness								Date: 8/7/2012 t Qty: 4.00		ed Date: 8/13/2012 red Qty: 4.00	
MS20470AD4-6 Rivet, Universal Head		Purchased	No			110	Each	3,170.0000	~ N	32 _		(
l				<u>Locatio</u>	<u>n</u>	Loc Qty		Loc Code				O P
				336		1500						
					122452	1500						
				ST319		1670						
					117395	16					•	
					118927	165						·
					119109	12						
					120142	81						
					121524	1396			1213	34		
MS21059L3 Nut Plate		Purchased	No			110	Each	396.0000	(<u>4</u> 16)	64M)2	2452	/
				<u>Locatio</u>	<u>n</u>	Loc Qty		Loc Code		/		~
				302		17						
					121185	17						
				314		200						
					122452	200						
				ST301		28						
				01501	118614	8			-			
					119546	20						
				ST302		151						
				31302	120308	131						
					120833	13						
_					121444	100					~	
					121524	37		•	1215.	17/6 y		
MS21072-L3		Purchased	No			110	Each	104.0000	100 m			
Nutplate		Purchased	110			110	Lacii	104.0000	المثنا	32 -	[c/2/s/	18
				Locatio	<u>n</u>	Loc Qty		Loc Code			, ,	/
				ST303	120308	1 1						(
				ST304		103						
				31304	121060				MIZI	<u>0</u> 60		
					121060	100			11121	<u></u>		
					121000	3						

NCR:	Yes	/ No				WORK ORDER NON-	COI	VFORN	MANCE / UPI	DATE			
						·					QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part No			Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	⊣	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root					Descri	ption of work order update	1	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							AUI	T CATE	GORY				
Landir	ng G	ear				General						<u> </u>	
		Bending Centre No Cracks Crushed/C Cuffs Heat Trea nspection	Crimped it n Strip in Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/U nance led	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \ Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	i l'	Torque W	aves in E	xtrusion	1 .	Drawing		Out of C	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

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· Picklist Print

Tuesday, August 07, 2012 3:26:22 PM

Work Order ID:

88845

Parent Item:

MS35207-267

D350-764-011

Parent Item Name:

Shoulder Harness

Purchased

No

Each

Start Date: 8/7/2012

Required Date: 8/13/2012

Page 9

Start Qty: 4.00

Required Qty: 4.00

Location Loc Qty Loc Code

110

ST294

119438 121060 100 99

100.0000

M12/060

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Shop Packet Print

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		•.	*	
DOM	Date:		*	
DQA:	Date.			•
-		 		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	•
Work Orde	r:		-		DISPOSITION			AGAINST DI	EPARTMENT	/PROCESS	
Part No			Rework Scrap Use-as-is Work Order Update	Th	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	- ₹	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root		T		Descri	ption of work order update	Initia	I A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	1	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling											
Operator Material											
Setup										·	
Other	-					l		•, t.	,		
Process	7										
Supplier	_										
Training									1	ľ	
Jnapproved											
		•			F	AULT CA	TEGORY			• •	
Landin	g Gear			-	General						
	Bending				Bend	Gra	in		Ovalized		Pressure/Forced
	Centre No	ot Concei	ntric to (o/s	BOM/Route	Hard	dware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ection Incomplete		Part Incorre	ct [Weld
	Crushed/0	Crimped.			Burrs	Insti	ructions Incomplete	:/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mai	ntenance		Part Moved		_
Ĺ	Heat Trea	it			Countersink	Misl	abeled		Positioned \	Wrong	
L	Inspection	n Strip in	Tube		Cut Too Short	Mist	ead		Power Loss/	'Surge	Other
L	Ripples in				Drill Holes	Offs	et				
L	Torque W	aves in E	xtrusion	\	Drawing	Out	of Calibration				
	Turning S	equence			Finish	Out	of Sequence				
- 1	Wayo/Twist in Tubo			Folio	1 0	ida Dimansians		·			

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REFERENCE ONLY

DART AEROSPACE USA, INC.

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5.0 **PARTS LISTS**

	QTY -011	Dart Part Number	Geneva Part Number	Description
	Х	D350-764-011	P131	Shoulder Harness Kit
	(4_	_D2854-1-080 /	N/A	VELCRO STRIP
	C 4	_D2854-3-080	⁷ N/A	VELCRO STRIP
	16	D3578-041	N/A	DOUBLER
	4-4	_D3636-041/	N/A	SHOULDER HARNESS
	4	*D3636-11	G10601-2	SHOULDER BELT
	4	*D3636-13	G10601-4	LAP BELT
1	4	-D3637-041 7	G10602-1	BRACKET ASSEMBLY
ı	₹ ⁴	D3637-3 /	G10609-1	BACKER PLATE
1	1 4	D3638-1 /	G10608-2	BUSHING
	ን 1	D3639-1	G10604-3	DOUBLER
	<u>-1</u>	⁻D3639-2	G10604-6	DOUBLER
	71-	-D3639-3	G10604-4	DOUBLER
A	1	D3639-4	G10604-5	DOUBLER
9	1 2	D3640-1 7	G10605-1	BELT GUIDE
	1 2	D3640-3	G10605-2	BELT GUIDE
	12	D3641-1 /	G10606-3/-6	COVER
		D3641-37	G10606-5	COVER
	ን 1	D3641-4 /	G10606-4	COVER
4	' 2	D3642-1 🟒	G10607-1/-2	DOUBLER
ď	1	D3643-1/_	G10610-2	STIFFENER
1	7 1	D3643-2 /	G10610-1	STIFFENER
	<u>L_2</u>	D3644-1	G10610-3	SHIM
	(1	D3657-1 /	G12170	GUIDE TOOL
			Ţ	
	/ 16	-ALS4-1032-130-	[*] N/A	INSERT
	/ 32	AN3-3A	N/A	BOLT
4	16	AN3-6A	N/A	BOLT
	4-	AN4-10A-7	N/A	BOLT
Į	/ 48	AN960JD10 7	N/A	WASHER
ı	4	AN960JD916 /	N/A	WASHER WASHER
-	4	AN970-6 /	N/A	
1	16	CCR264SS-3-03	N/A N/A	RIVET RIVET
ı	4	CR3212-4-02 / CR3212-5-04 /	N/A N/A	RIVET
Ą	7 4		N/A N/A	RIVET
	32	CR3212-5-07 7 MS20426AD3-3 7	N/A N/A	RIVET
		MS20426AD3-3 /	N/A	RIVET
4	- 106 2 28	MS20426AD4-6	-N/A	RIVET
	<u>7</u> 28 <u>4</u> 8	MS20470AD4-6	TN/A N/A	RIVET
ı		MS21059L3 4	N/A	NUTPLATE (OR MS21059-3)
1	<u>/ 16</u> <u> </u>	=MS21059L3 ==	N/A N/A	NUTPLATE (OR MS21039-3)
1	8 8	MS35206-267	N/A	SCREW
	4_0-2		IN/A	

*Included with D3636-041

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Revision: **B**

Date: 07.10.16